

split
Work Order ID 126538-2

Thursday, November 13, 2014 8:31:23 AM

126538

Ship NOV. 21

Page 1

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14

Start Qty: ~~25.00~~

Required Date: 11/20/14

Req'd Qty: 25.00

Reference:

Accept

N9000040100

Setup Start

Stop

NS1

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: *[Signature]*

Date: 14-11-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3779	C								

100

100

Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

6061.125

Memo

1-Cut D3779-5 as per Dwg D3779

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

28

0

DAS

23

9-89

14-11-13

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

28

0

DAS

23

9-89

14-11-13

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

28

DAS

38

9-89

NOV 13 2014

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 2

Item ID: D3779-043
 Revision ID:
 Item Name: Handle Assembly (Interior)
 Start Date: 11/17/14 Start Qty: 25.00
 Required Date: 11/20/14 Req'd Qty: 25.00
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- counter sink holes as per dwg D3779 2- deburr								14/11/17
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							28
Quality Control									38 9-89
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									28. 6 14-11-18

NOV 17 2014

34
9-89

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 3

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

Required Date: 11/20/14 Req'd Qty: 25.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160					DAS				
QC	Memo	0.00			30	10			11/14/25
Quality Control					9-89				
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00				10	FF	NOV 25 2014	P.T.O.
Small Fab	1- rivet D3203-1 handle to D3779-5 plate as per dwg D3779 per QSI003								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00				10			DAS
Quality Control									38
									9-89

NOV 25 2014

ADAM S. FORD

DQA: OK Date: 14/12/17

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 8/10/16 Date: 14/12/16Work Order update only ☐

Work Order: <u>126538</u> Part No. <u>D3779-043</u> <u>D3203-1</u> NCR No. <u>14-4487</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
--	---	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
	<u>14/11/25</u>	<u>180</u>	<u>2</u>	<u>2 handles crack</u> <u>when were press</u> <u>on the manual</u> <u>press</u> <u>Re-check product</u> <u>RC. Process / material</u> <u>is very brittle made of</u> <u>cast AC</u> <u>re-process</u>	<u>5</u> <u>14/12/15</u> <u>Q2012</u>	<u>Scrap &</u> <u>destroy</u> <u>No replace</u> <u>replace</u> <u>D3203-1</u> <u>B 126533</u> <u>\$7.81</u>	<u>FF</u> <u>NOV 25 2014</u>	<u>DAS</u> <u>30</u> <u>9-89</u> <u>14/11/25</u>	<u>5</u> <u>14/12/15</u>

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input checked="" type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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MON 2 1 1974

Work Order ID 126538

Thursday, November 13, 2014 8:31:23 AM

126538

Page 4

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 11/17/14 Start Qty: 25.00

Required Date: 11/20/14 Req'd Qty: 25.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>SLS</u>	0.00							
200									
Packaging	Memo	0.00				<u>10</u>	DAS 46	NOV 26 2014	
Packaging							9-89		
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

14/12/2 *[Signature]**[Signature]* 14-11-27

Picklist Print

Thursday, November 13, 2014 8:31:30 AM

Page 1

Work Order ID: 126538

Parent Item: D3779-043

Parent Item Name: Handle Assembly (Interior)

126538

D3779-043

Start Date: 11/17/14

Required Date: 11/20/14

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC IPP Rev:C
11.12.02 as per dwg revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

149.3910

0.4365

12

(14)

M

14-11-13

M6061T6S 125

6061-T6 .125 Sheet

**

Location

Loc Qty

Loc Code

MAT021

149.391

m127272

29.2

m127454

24.703

m127501

5.1

m128852

6.938

m130524

21.45

m130745

62

130524

D3203-1

Manufactured

No

180

Each

17.0000

1

25

D3203-1

Handle

**

FF

NOV 25 2014

Location

Loc Qty

Loc Code

ST490

17

126533

17

126443

180

Each

118.0000

4

100

MS20426AD10-9A

Purchased

No

MS20426AD10-9A

RIVET

**

FF

NOV 25 2014

Location

Loc Qty

Loc Code

ST311

118

125170

1

M127659

17

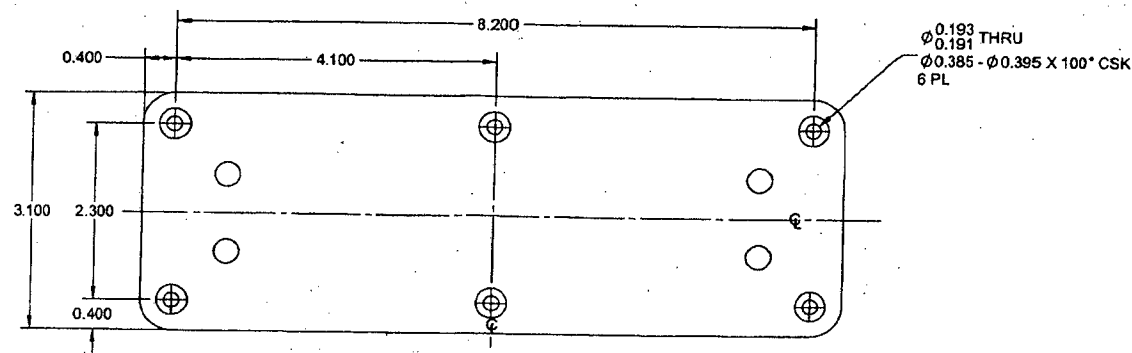
M130862

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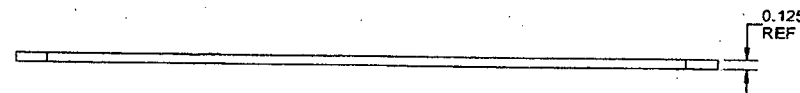
40

Ad. 30

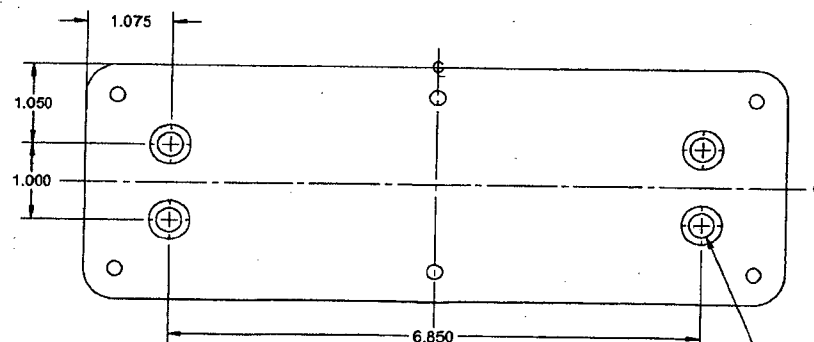
Ad. 30



0.193 THRU
0.385 - 100° CSK
6 PL



0.125
REF



0.322 THRU
0.515 - 100° CSK
4 PL

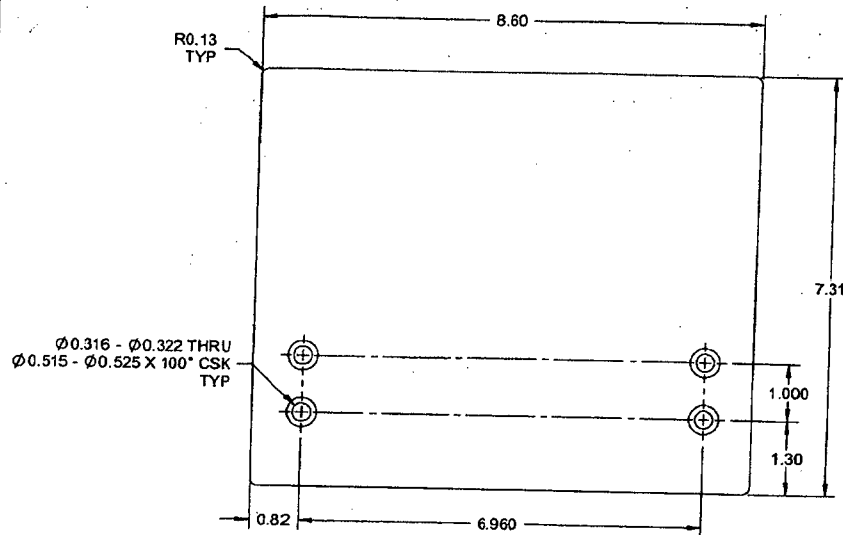
D3779-1 PLATE

NOTES:

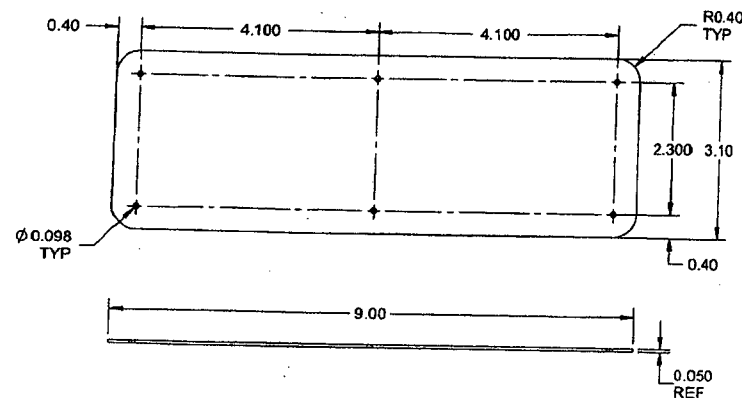
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

RELEASED
2012-07-23
JMS

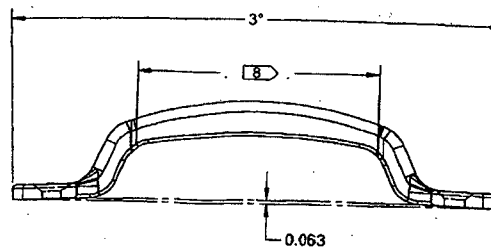
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DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	E.O.	D3779	SHEET 3 OF 4
APPROVED	JMS	TITLE	SCALE
DE APPR.	JMS	HANDLE ASSEMBLY CABIN SLIDING DOOR	NTS
DATE	12.04.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3779-5 PLATE



D3779-3 DOUBLER PLATE



D3779-7 HANDLE, MODIFIED

NOTES:

1) MATERIAL:

D3779-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.050)

D3779-5: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027
(REF DART SPEC M6061T6S.125)

D3779-7: MADE FROM D3203-1

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: D3779-3: IDENTIFY WITH DART P/N "D3779-3" AND B/N "BXXXXX" PER DART QSI 044 6.1

D3779-5: NONE
D3779-7: NONE

7) WEIGHT: D3779-3: 0.14 lbs

D3779-5: 0.76 lbs

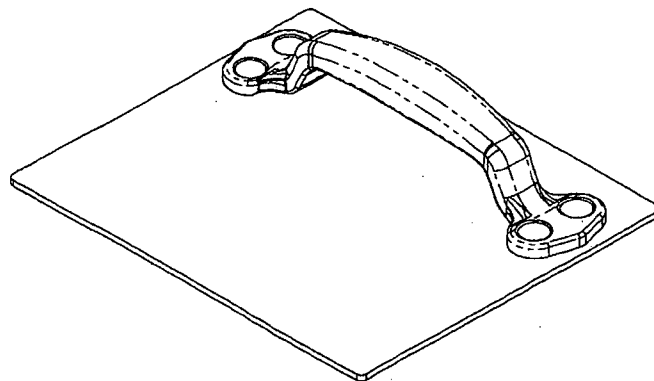
D3779-7: 0.38 lbs

8) BEND HANDLE THROUGH THIS AREA ONLY

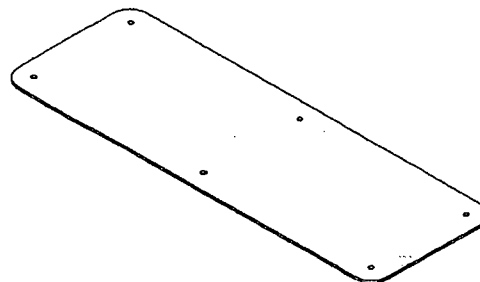
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2012-07-23

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DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3779	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE	12.04.26	NTS	
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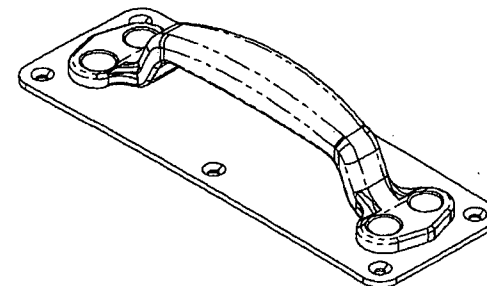
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
1		D3779-7	HANDLE
4	4	MS20426AD10-9A	RIVET, CSK



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**



D3779-3 DOUBLER PLATE



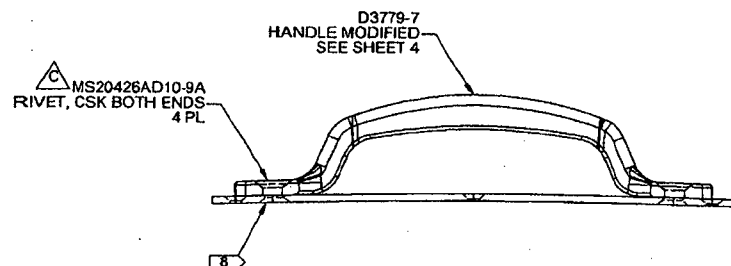
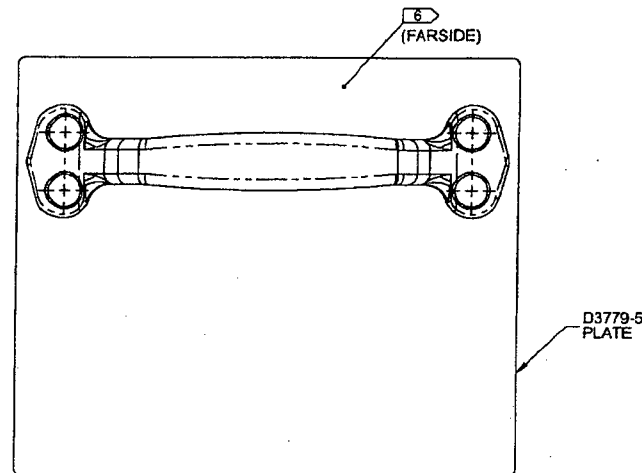
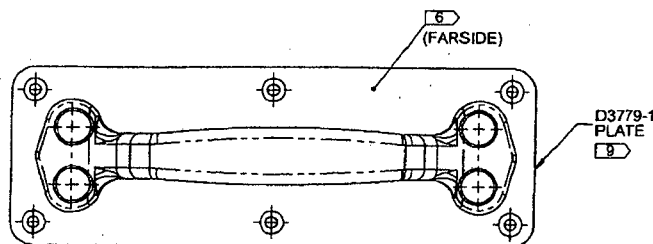
**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: (SEE SHEETS 2 & 3)
 7) WEIGHT: D3779-3: 0.14 lbs
 D3779-041: 0.71 lbs
 D3779-043: 1.14 lbs

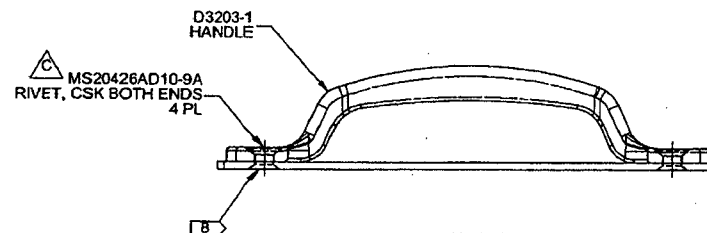
RELEASED
 2012-07-23
W

C	CHANGED RIVET FROM -8 TO -9A CHANGED D3779-041 FROM FLAT TO CONTOURED	RP	12.04.26
B	REFORMAT JAW DART QSI 043; MS20426AD10-9 WAS MS20426AD10-8 (2N D6-1, 98/84-2) REASON: PRODUCTION FACILITY (PAR11-136)	MB	11.11.24
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3779	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HANDLE ASSEMBLY, CABIN SLIDING DOOR	
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11-11-2
126538



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-XXX" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: D3779-041: 0.71 lbs
D3779-043: 1.14 lbs
- 8) RIVETS TO BE PEENED AND GROUND FLUSH
- 9) FORMED TO FIT D3779-7 HANDLE DURING ASSEMBLY.

RELEASED
2012-07-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. D3779	REV. C
MFG. APPR.	Eg	SHEET 2 OF 4	
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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FIRST ARTICLE INSPECTION CHECKLIST

DAC39Revised by

